



Dart Hawkesbury  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

**D350-636-015**  
**Job Sheet 167302-B**



Part No: D350-636-015

Job Qty: 1 ea

Part Name: Skidtube LH, Run-on Landing Wearplates, DART(Apical) Cylind./Aerazur Float Comp.



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/27/17

Job Tracking No:

Due Date: 11/24/17

Created By: Mario Poulin

Type: Stock

Description:

Customer: Air Methods Corporation (CAMET01)

7301 South Peoria Street Englewood, CO, 80112 USA ph:(303) 792-7400

Ship Via: *Aug Rev B*

*PMA*

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off                |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|-------------------------|
|       |                    |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |                         |
| 90    | Start up Operation | 1 Ea  |            | 11/23/17 | 0.00      | 0.00    | Start Up Skidtubes    |           | <i>BE</i>               |
| 110   | Skidtubes          | 1 pcs |            | 11/23/17 | 0.00      | 5.25    | Skidtubes             |           | <i>BE</i>               |
| 120   | QC                 | 1 pcs |            | 11/23/17 | 0.00      | 0.00    | QC10                  |           | <i>38 DAB</i>           |
| 130   | QC                 | 1 pcs |            | 11/23/17 | 0.00      | 0.00    | QC5                   |           | <i>38</i>               |
| 140   | HandFinish         | 1 pcs |            | 11/23/17 | 0.00      | 0.99    | HandFinish1           |           | <i>2018/01/22 JSL</i>   |
| 150   | QC                 | 1 pcs |            | 11/23/17 | 0.00      | 0.00    | QC7                   |           | <i>BE</i>               |
| 160   | Skidtubes          | 1 pcs |            | 11/23/17 | 0.00      | 5.25    | Skidtubes             |           | <i>MBG BE</i>           |
| 170   | QC                 | 1 pcs |            | 11/23/17 | 0.00      | 0.00    | QC10                  |           | <i>EB</i>               |
| 180   | QC                 | 1 pcs |            | 11/23/17 | 0.00      | 0.00    | QC5                   |           | <i>EB</i>               |
| 190   | HandFinish         | 1 pcs |            | 11/23/17 | 0.00      | 0.99    | HandFinish2           |           | <i>18-01-31 JSL</i>     |
| 200   | SprayPaint         | 1 pcs |            | 11/23/17 | 0.00      | 0.67    | Spray Paint           |           | <i>BE</i>               |
| 210   | QC                 | 1 pcs |            | 11/23/17 | 0.00      | 0.00    | QC14                  |           | <i>BEB 18-02-06</i>     |
| 230   | HandFinish         | 1 pcs |            | 11/24/17 | 0.00      | 0.99    | HandFinish2           |           | <i>BEB 18-02-06</i>     |
| 240   | QC                 | 1 pcs |            | 11/24/17 | 0.00      | 0.00    | QC5                   |           | <i>BE</i>               |
| 250   | Packaging          | 1 pcs |            | 11/24/17 | 0.00      | 0.00    | Packaging1            |           | <i>2018 FEB 20 2018</i> |
| 260   | QC                 | 1 pcs |            | 11/24/17 | 0.00      | 0.00    | QC4                   |           | <i>MBG</i>              |
| 265   | DC                 | 1 pcs |            | 11/24/17 | 0.00      | 0.00    | DC                    |           | <i>MBG</i>              |
| 270   | Packaging          | 1 pcs |            | 11/24/17 | 0.00      | 0.00    | Packaging3            |           | <i>MBG</i>              |
| 280   | QC21-FG            | 1 Ea  |            | 11/24/17 | 0.00      | 0.00    | QC21                  |           | <i>21 FEB 20 2018</i>   |

Part Op 110 - 1- Pick D2600-3 Bent 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg  
Descriptions: D4168 Drill pilot holes as per Dwg D4168 sheet 4 (D4168-1 details). Drill using drill Jig DT8150 & DT8863A for first side  
only DT8863B for second side (detail B) 4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade  
fitting, section H-H. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE. 5- Drill tow ring hole  
using DT9616 detail "A" 6- Drill most FWD wearplate hole using DT9678 locating off of 66.54" hole. 7- Open up holes of  
Detail A to 0.297" (total of 2 holes per side) and .201" (total of 1 hole per side) 8- Weld D2744 Cap as per Dwg D4168 and  
QSI 004. Fill grooves in bend left from bending as per QSI 004 9- Grind welds flush as per Dwg D4168  
160 - 1- Open up holes using hole saw of Detail C and ground handling section AL-AL to 0.625" (total of 8 holes per side)  
as per dwg D4168. 3- Open float hole to 0.500" using uni-bit (4 per side) section AJ-AJ Open wearplate holes to size as  
per dwg (4 holes per sides) , section CG-CG 4- Chamfer holes of Detail B, C, ground handling section AL-AL and float  
holes section AJ-AJ per dwg D4168 (welding instructions on sheet 8) 7- Bond web D2739 in place as per QSI 015, let cure  
for 12hrs. A/R exp. date: *2018-04-11* \*\*\*ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)\*\*\* 8- Weld spacers  
D3490-1, D3490-3 and D2743 as per dwg D4168 and D4170-1 & QSI004 10- Grind welds flush as per Dwg D4168 11-  
Spot face ground handling holes section (total of 4 places per side) as per dwg D4168, section AL-AL 12- C'bore section  
CG-CG. ADJUST TOOLING AS REQUIRED. VERF BY: \_\_\_\_\_ 13- Deburr holes, ensure tube is free of  
all scratches before sending to paint. \*\*\*\*\* FOR DELUXE SKIDTUBE IF APPLICABLE DRILL TOW RING HOLE IN

*AIR BE*  
*M138673*  
*M136158*  
*Skaflex*  
*Batch #*  
*M138654*

*000471*



**DART**  
AEROSPACE  
**S033030**

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Skidtube LH, Run-on Landing Wearplates, DART(Apical)  
Cylind./Aerazur Float Comp.

**PART NO: D350-636-015**  
**Original Serial #: S033030**

**Revision:**

**Operation:**

**Change No:**

**Start up Operation** 01/17/18  
**CHG005** Job No: 167302-B

TUBE \*\*\*\*\* REF TO W/O BATCH: \*\*\*\*\*

180 - \*\*\*VERIFY C'BOARD IS GOOD\*\*\*

190 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200 - 1- PRIME AS PER DWG AND QSI 005 4.2

210 - Inspect for foreign object per QSI 024

230 - 1- Install inserts as per Dwg D4168 3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D4168 5-Coat all exposed fasteners with "LPS Procyon" batch: 1133680

250 - If making a D350-636-215 pick kit will only requires: 1 X AN3C37A 1 X AN3C34A 1 X AN3C42A 2 X D3493-1

260 - \*\*\*\*\*ensure antiseize is on AN8C21A bolts\*\*\*\*\*

265 - record fwd angle: 90.0 Photocopy blue file and type labels per PPP D350-636-015 CHG 005

270 - Identify and pack for shipping as per PPPD350-636-015 Location :FG071

## Job Allocations

| Operation             | Component Part                   | Required | Inventory | Allocated | Std Qty |
|-----------------------|----------------------------------|----------|-----------|-----------|---------|
| 90-Start up Operation | D2600-3-BENT-LH <u>50315380</u>  | 1        | 2         | 0         | 0       |
|                       | D2744 <u>5003318</u>             | 1        | 0         | 0         | 0       |
| 160-Skidtubes         | D2739 <u>5032813</u>             | 1        | 15        | 0         | 0       |
|                       | D2743 <u>5026588</u>             | 8        | 145       | 0         | 0       |
|                       | D3490-1 <u>5017322</u>           | 4        | 33        | 0         | 0       |
|                       | D3490-3 <u>5030890</u>           | 4        | 20        | 0         | 0       |
|                       | ALS4-1032-225 <u>5007280</u>     | 4        | 897       | 0         | 0       |
| 230-HandFinish        | AN3C34A <u>5000940</u>           | 1        | 19        | 0         | 0       |
|                       | AN3C36A <u>FM135720</u>          | 4        | 586       | 0         | 0       |
|                       | AN3C6A <u>5019397</u>            | 4        | 88        | 0         | 0       |
|                       | AN6C44A <u>FM137055-1</u>        | 4        | 251       | 0         | 0       |
|                       | AN8C35A <u>FM137203</u>          | 1        | 99        | 0         | 0       |
|                       | D2745 <u>5026436</u>             | 8        | 92        | 0         | 0       |
|                       | D3488-041 <u>F163322</u>         | 1        | 10        | 0         | 0       |
|                       | D3492-1 <u>5025647</u>           | 8        | 59        | 0         | 0       |
|                       | D3492-3 <u>5026057</u>           | 8        | 101       | 0         | 0       |
|                       | D3631-1 <u>5005168</u>           | 8        | 4         | 0         | 0       |
|                       | D3873-1 <u>5001354</u>           | 7        | 171       | 0         | 0       |
|                       | D4154-041 <u>F163961</u>         | 1        | 7         | 0         | 0       |
|                       | D4170-1                          | 4        | 22        | 0         | 0       |
|                       | D4171-1 <u>F153784</u>           | 1        | 13        | 0         | 0       |
|                       | MS21043-3 <u>FM136182-40</u>     | 5        | 829       | 0         | 0       |
|                       | MS21043-6 <u>5016883</u>         | 4        | 66        | 0         | 0       |
|                       | MS21083C8 <u>5034401</u>         | 1        | 7         | 0         | 0       |
|                       | NAS1149C0332R <u>5019380-1</u>   | 4        | 4,758     | 0         | 0       |
|                       | NAS1149C0363R <u>5017102</u>     | 9        | 221       | 0         | 0       |
|                       | NAS1149C0832R <u>FM135536-01</u> | 1        | 118       | 0         | 0       |
|                       | NAS1515H3L <u>FM137361-25</u>    | 4        | 222       | 0         | 0       |
|                       | NAS1611-010 <u>5022098</u>       | 8        | 123       | 0         | 0       |
|                       | NAS1611-013 <u>5022099</u>       | 8        | 117       | 0         | 0       |
| 250-Packaging         | AN3C37A                          | 1        | 68        | 0         | 0       |
|                       | AN3C42A                          | 1        | 60        | 0         | 0       |
|                       | AN8C21A                          | 2        | 239       | 0         | 0       |
|                       | D2741                            | 1        | 70        | 0         | 0       |
|                       | D3493-1                          | 2        | 42        | 0         | 0       |
|                       | MS21083C8                        | 2        | 7         | 0         | 0       |
|                       | NAS1149D0863J                    | 2        | 209       | 0         | 0       |

8164069 x 2  
5019233 x 2

## Part Specifications

Specifications could not be found.

Plex 10/27/17 2:37 PM dart.poulin.mario

| QTY<br>-041 | QTY<br>-042 | QTY<br>-043 | QTY<br>-044 | PART NUMBER   | DESCRIPTION               |
|-------------|-------------|-------------|-------------|---------------|---------------------------|
| X           |             |             |             | D4168-041     | 350 SKIDTUBE ASSEMBLY, LH |
|             | X           |             |             | D4168-042     | 350 SKIDTUBE ASSEMBLY, RH |
|             |             | X           |             | D4168-043     | 350 SKIDTUBE ASSEMBLY, LH |
|             |             |             | X           | D4168-044     | 350 SKIDTUBE ASSEMBLY, RH |
| 1           | 1           | 1           | 1           | D2739         | WEB                       |
| 8           | 8           | 8           | 8           | D2743         | SPACER                    |
| 1           | 1           | 1           | 1           | D2744         | CAP                       |
| 8           | 8           | 8           | 8           | D2745         | BUSHING                   |
| 1           |             | 1           |             | D3488-041     | BLADE FITTING, LH         |
|             | 1           |             | 1           | D3488-042     | BLADE FITTING, RH         |
| 4           | 4           | 4           | 4           | D3490-1       | SPACER                    |
| 4           | 4           |             |             | D3490-3       | SPACER                    |
|             |             | 4           | 4           | D3490-5       | SPACER                    |
| 8           | 8           | 8           | 8           | D3492-041     | PLUG ASSEMBLY             |
| 8           | 8           |             |             | D3492-043     | PLUG ASSEMBLY             |
|             |             | 8           | 8           | D3492-045     | PLUG ASSEMBLY             |
| 8           | 8           | 8           | 8           | D3631-1       | WASHER                    |
| 7           | 7           | 7           | 7           | D3873-1       | BUSHING                   |
| 1           | 1           | 1           | 1           | D4154-041     | WEARPLATE ASSEMBLY        |
| 1           |             |             |             | D4168-1       | SKIDTUBE WELDMENT, LH     |
|             | 1           |             |             | D4168-2       | SKIDTUBE WELDMENT, RH     |
|             |             | 1           |             | D4168-3       | SKIDTUBE WELDMENT, LH     |
|             |             |             | 1           | D4168-4       | SKIDTUBE WELDMENT, RH     |
| 4           | 4           | 4           | 4           | D4170-1       | SPACER                    |
| 1           | 1           | 1           | 1           | D4171-1       | BUSHING                   |
| 4           | 4           | 4           | 4           | ALS4-1032-225 | INSERT                    |
| 4           | 4           | 4           | 4           | AN3C8A        | BOLT                      |
| 1           | 1           | 1           | 1           | AN3C34A       | BOLT                      |
| 4           | 4           | 4           | 4           | AN3C38A       | BOLT                      |
| 4           | 4           | 4           | 4           | AN6C44A       | BOLT                      |
| 1           | 1           | 1           | 1           | AN6C35A       | BOLT                      |
| 9           | 9           | 9           | 9           | AN960C10      | WASHER (OR NAS1149CO363R) |
| 4           | 4           | 4           | 4           | AN960C10L     | WASHER (OR NAS1149CO332R) |
| 1           | 1           | 1           | 1           | AN960C816L    | WASHER (OR NAS1149CO832R) |
| 5           | 5           | 5           | 5           | MS21043-3     | NUT                       |
| 4           | 4           | 4           | 4           | MS21043-6     | NUT                       |
| 1           | 1           | 1           | 1           | MS21083C8     | NUT                       |
| 4           | 4           | 4           | 4           | NAS1515H3L    | WASHER                    |

# GENERAL NOTES:

- MATERIAL: MAKE D4168-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2  
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.J) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D4168-041/-042/-043/-044 = 32.3 LBS
- WELD PER DART QSI 004
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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NO. 167302-15

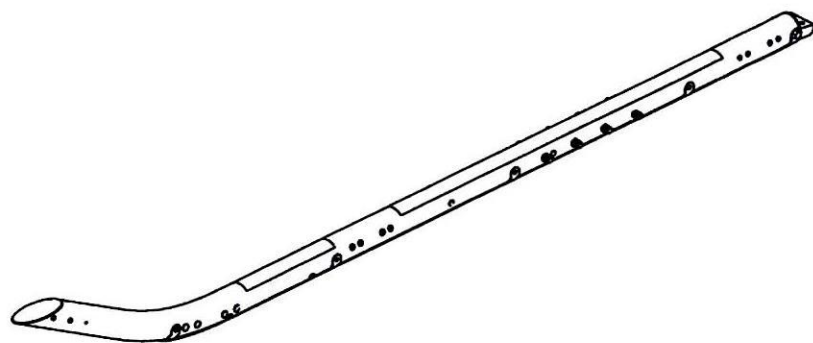
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2013-08-13  
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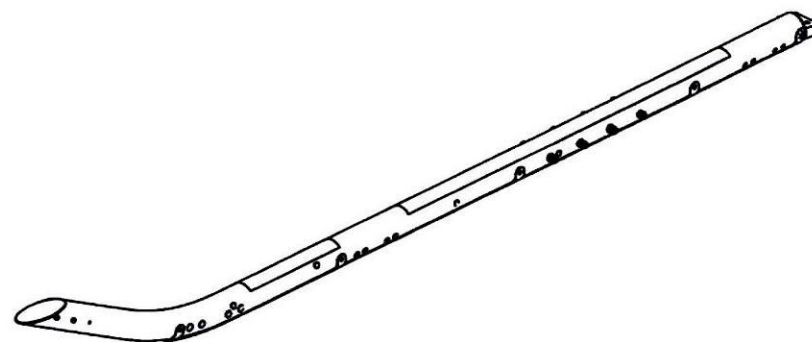
|            |                                                                                                                           |    |          |
|------------|---------------------------------------------------------------------------------------------------------------------------|----|----------|
| B          | ADD VIEW TO CONTROL FWD BEND ORIENTATION<br>(ZV D-1-4-5-6-7); UPDATED FINISH OPTIONS.<br>REASON: PARTS-276 AND NCR15-2757 | MB | 13.07.11 |
| A          | NEW ISSUE                                                                                                                 | SC | 10.08.09 |
| REV.       | DESCRIPTION                                                                                                               | BY | DATE     |
| DESIGN     | SE                                                                                                                        |    |          |
| DRAWN      | SE                                                                                                                        |    |          |
| CHECKED    | SE                                                                                                                        |    |          |
| MFG. APPR. | SE                                                                                                                        |    |          |
| APPROVED   | SE                                                                                                                        |    |          |
| DE APPR.   | SE                                                                                                                        |    |          |
| DATE       | 13.07.11                                                                                                                  |    |          |

|                                                                                                                                                                                                                                                |               |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------|
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| KENT, WA                                                                                                                                                                                                                                       |               |
| DRAWING NO.                                                                                                                                                                                                                                    | REV. B        |
| D4168                                                                                                                                                                                                                                          | SHEET 1 OF 11 |
| TITLE                                                                                                                                                                                                                                          | SCALE         |
| 350 SKIDTUBE ASSEMBLY                                                                                                                                                                                                                          | NTS           |
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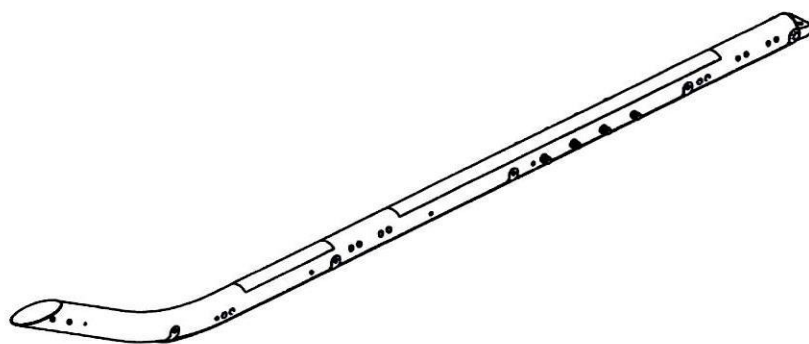
**D4168-041 350 SKIDTUBE ASSEMBLY, LH**



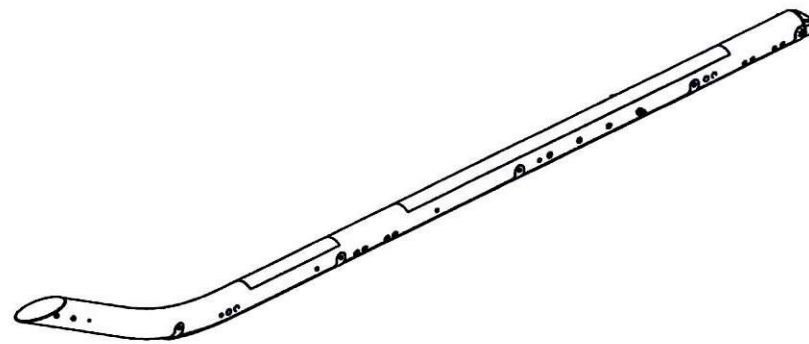
**D4168-042 350 SKIDTUBE ASSEMBLY, RH**

**RELEASE**  
2013-08-13  
*AW*

|            |                    |                                                                                                                                                                                                                                                                                                      |               |
|------------|--------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------|
| DESIGN     | SC                 | <b>DART AEROSPACE USA, INC.</b>                                                                                                                                                                                                                                                                      |               |
| DRAWN      | <i>[Signature]</i> | KENT, WA                                                                                                                                                                                                                                                                                             |               |
| CHECKED    | <i>[Signature]</i> | DRAWING NO.                                                                                                                                                                                                                                                                                          | REV. B        |
| MFG. APPR. | <i>[Signature]</i> | <b>D4168</b>                                                                                                                                                                                                                                                                                         | SHEET 2 OF 11 |
| APPROVED   |                    | TITLE                                                                                                                                                                                                                                                                                                | SCALE         |
| DE APPR.   |                    | <b>350 SKIDTUBE ASSEMBLY</b>                                                                                                                                                                                                                                                                         | NTS           |
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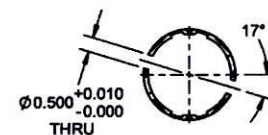
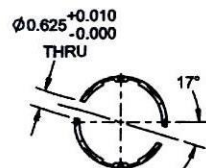
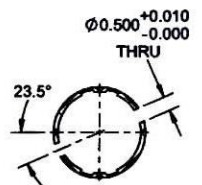
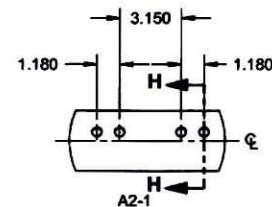
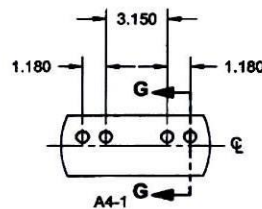
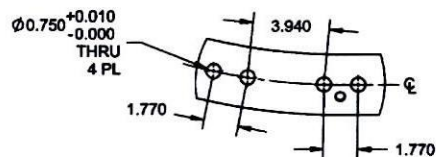
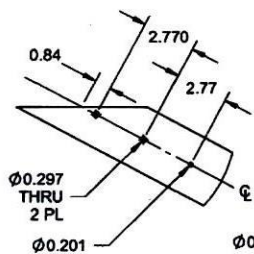
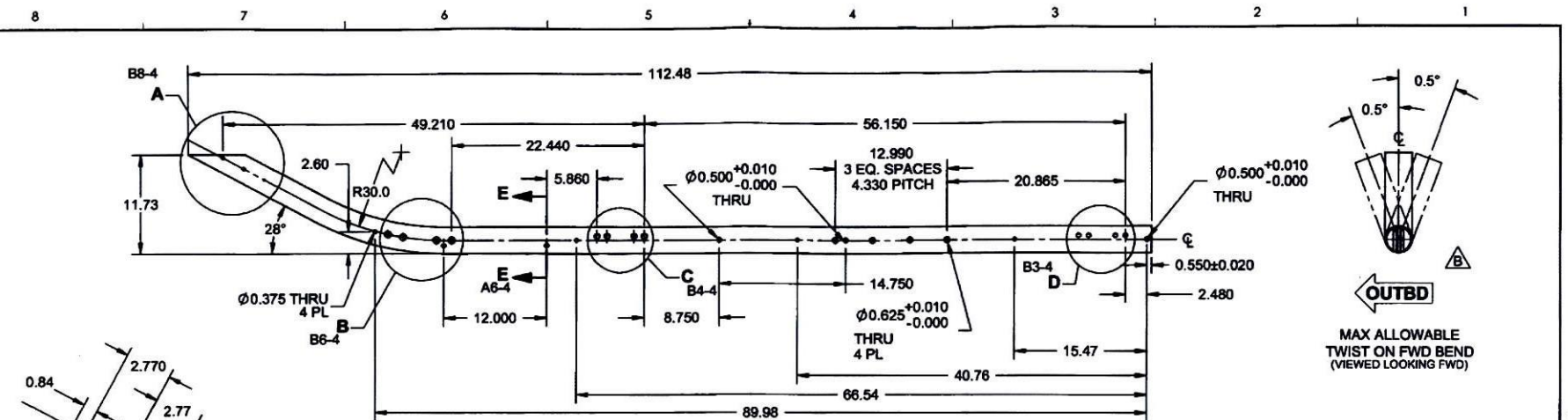
**D4168-043 350 SKIDTUBE ASSEMBLY, LH**



**D4168-044 350 SKIDTUBE ASSEMBLY, RH**

**RELEASED**  
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|            |          |                                                                                                                                                                                                                                                                                                                   |               |
|------------|----------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------|
| DESIGN     | SC       | <b>DART AEROSPACE USA, INC.</b>                                                                                                                                                                                                                                                                                   |               |
| DRAWN      | SC       | KENT, WA                                                                                                                                                                                                                                                                                                          |               |
| CHECKED    | SC       | DRAWING NO.                                                                                                                                                                                                                                                                                                       | REV. B        |
| MFG. APPR. | SC       | <b>D4168</b>                                                                                                                                                                                                                                                                                                      | SHEET 3 OF 11 |
| APPROVED   | SC       | TITLE                                                                                                                                                                                                                                                                                                             | SCALE         |
| DE APPR.   | SC       | <b>350 SKIDTUBE ASSEMBLY</b>                                                                                                                                                                                                                                                                                      | NTS           |
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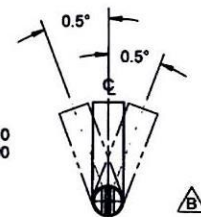
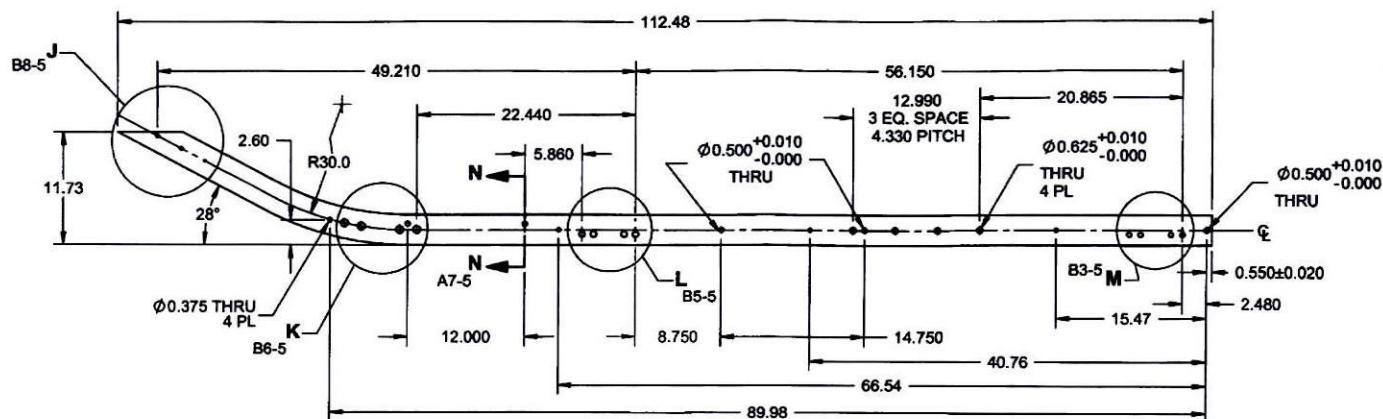
**SECTION H-H**  
SCALE 3X, 4 PL

DESIGN  
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MFG. APPR.  
APPROVED  
DE APPR.  
DATE 13.07.11

**DART AEROSPACE USA, INC.**  
KENT, WA

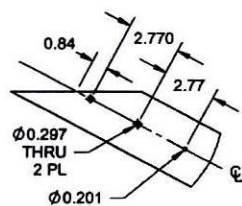
DRAWING NO. **D4168**  
TITLE **350 SKIDTUBE ASSEMBLY**  
REV. A  
SHEET 4 OF 11  
SCALE  
NTS

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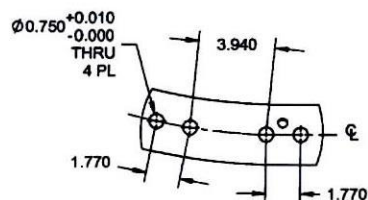


MAX ALLOWABLE  
TWIST ON FWD BEND  
(VIEWED LOOKING FWD)

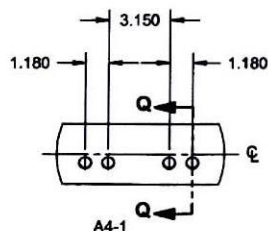
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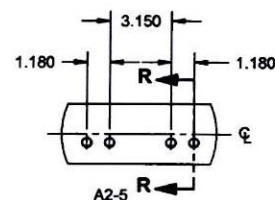
**DETAIL J**  
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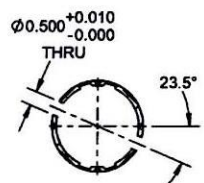
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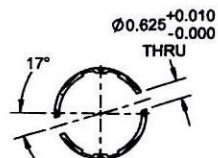
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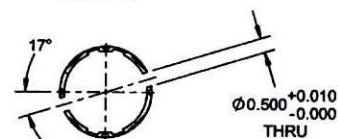
**DETAIL M**  
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**SECTION N-N**  
SCALE 3X, 2 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL

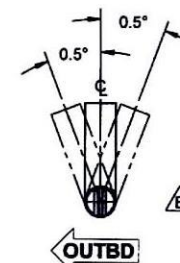
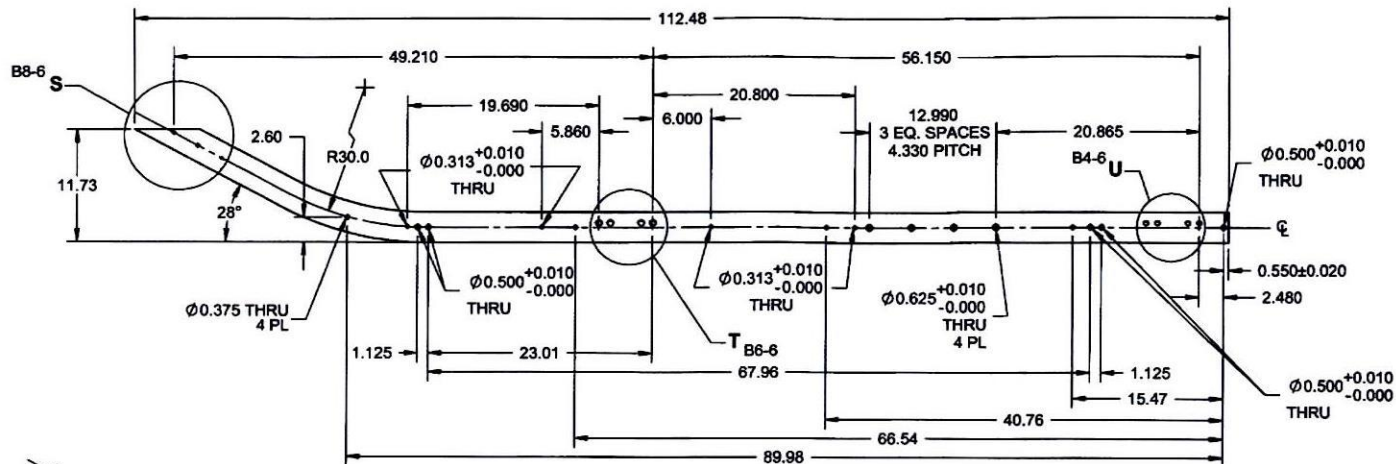


**SECTION R-R**  
SCALE 3X, 4 PL

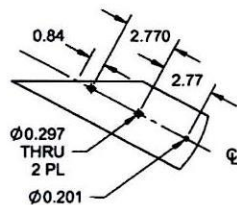
**RELEASED**  
2013-08-13  
JMT

|                 |  |    |  |                                                                                                                                                                                                                                         |  |
|-----------------|--|----|--|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|
| DESIGN<br>DRAWN |  | SC |  | DART AEROSPACE USA, INC.                                                                                                                                                                                                                |  |
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| MFG. APPR.      |  |    |  | DRAWING NO. D4168                                                                                                                                                                                                                       |  |
| APPROVED        |  |    |  | REV. B                                                                                                                                                                                                                                  |  |
| DE APPR.        |  |    |  | SHEET 5 OF 11                                                                                                                                                                                                                           |  |
| DATE 13.07.11   |  |    |  | SCALE NTS                                                                                                                                                                                                                               |  |
|                 |  |    |  | TITLE 350 SKIDTUBE ASSEMBLY                                                                                                                                                                                                             |  |
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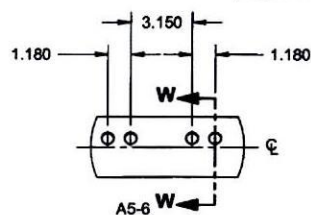




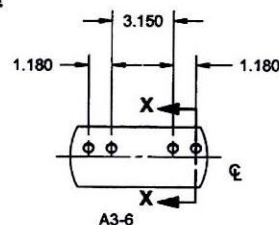
MAX ALLOWABLE  
TWIST ON FWD BEND  
(VIEWED LOOKING FWD)



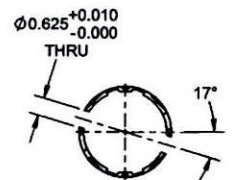
**DETAIL S** D8-6  
SCALE 2X



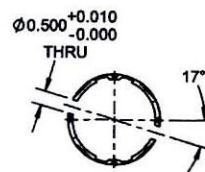
**DETAIL T** C5-6  
SCALE 2X



**DETAIL U** D3-6  
SCALE 2X



**SECTION W-W** B6-6  
SCALE 3X, 4 PL



**SECTION X-X** B4-6  
SCALE 3X, 4 PL

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CHECKED  
MFG. APPR.  
APPROVED  
DE APPR.  
DATE 13.07.11

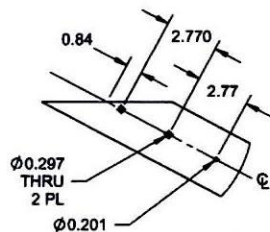
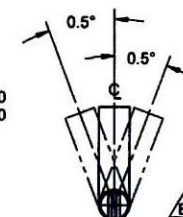
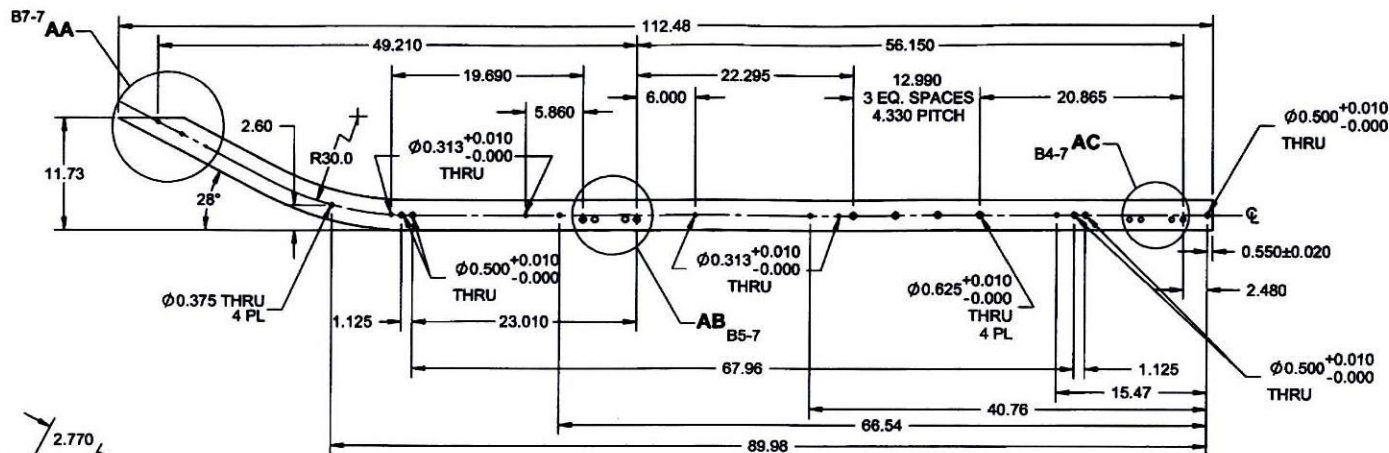
**DART AEROSPACE USA, INC.**  
KENT, WA

DRAWING NO. **D4168**  
TITLE **350 SKIDTUBE ASSEMBLY**  
REV. B  
SHEET 6 OF 11  
SCALE  
NTS

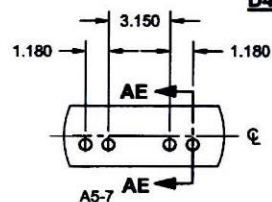
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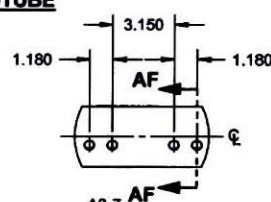
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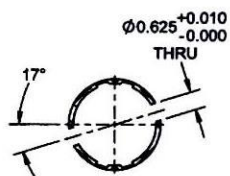
**DETAIL AA**  
SCALE 2X



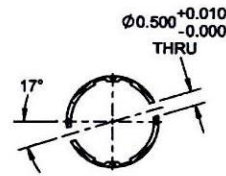
**DETAIL AB**  
SCALE 2X



**DETAIL AC**  
SCALE 2X



**SECTION AE-AE**  
SCALE 3X, 4 PL

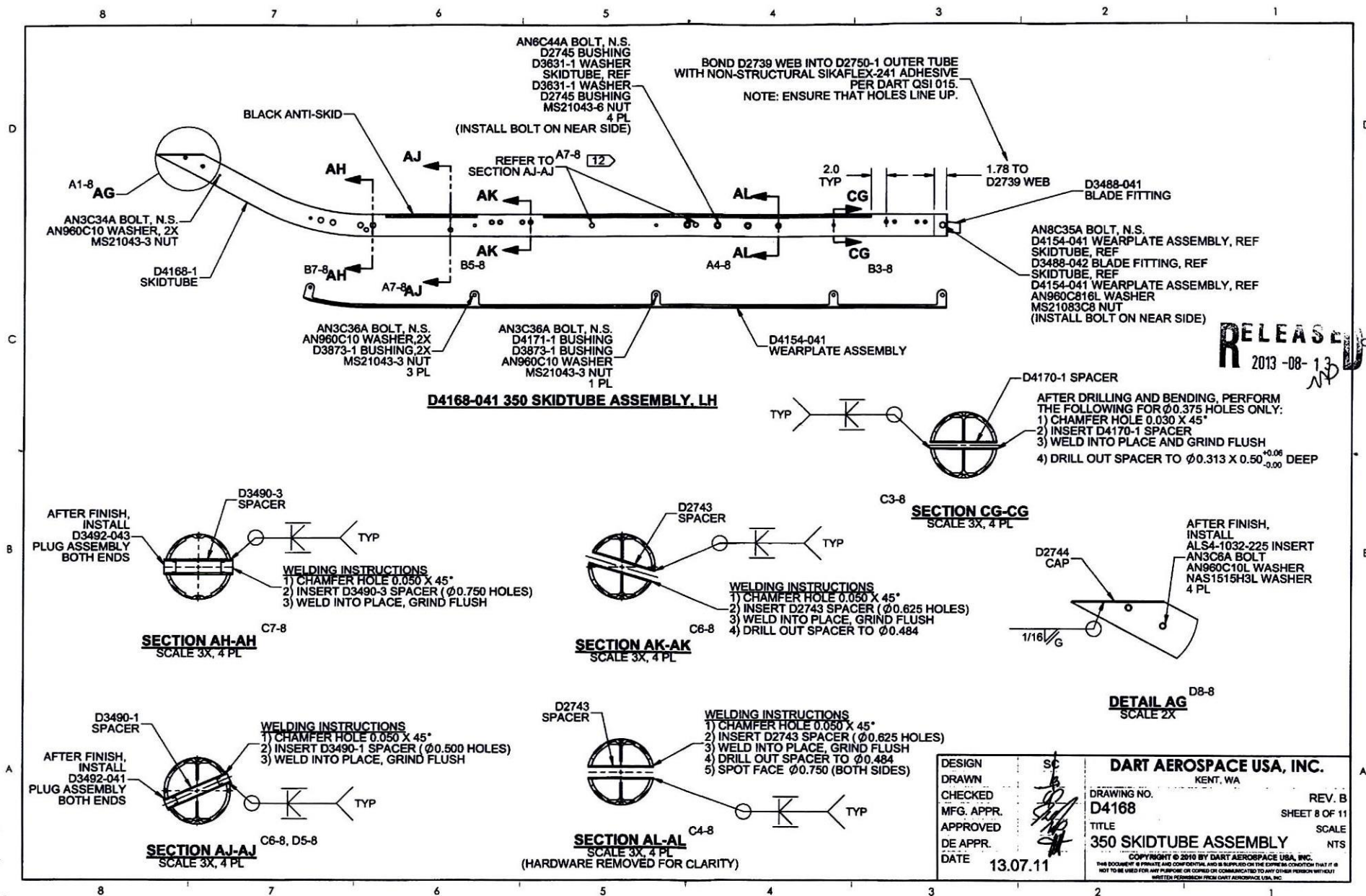


**SECTION AF-AF**  
SCALE 3X, 4 PL

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|                                                                          |                               |                                                                                                                                                                                                                                                                                                                                                                                                                     |  |
|--------------------------------------------------------------------------|-------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|
| DESIGN<br>DRAWN<br>CHECKED<br>MFG. APPR.<br>APPROVED<br>DE APPR.<br>DATE | SC<br>B<br>J<br>H<br>13.07.11 | <b>DART AEROSPACE USA, INC.</b><br>KENT, WA<br>DRAWING NO. <b>D4168</b><br>TITLE <b>350 SKIDTUBE ASSEMBLY</b><br>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.<br><small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> |  |
|                                                                          |                               | REV. B<br>SHEET 7 OF 11<br>SCALE<br>NTS                                                                                                                                                                                                                                                                                                                                                                             |  |

8 7 6 5 4 3 2 1

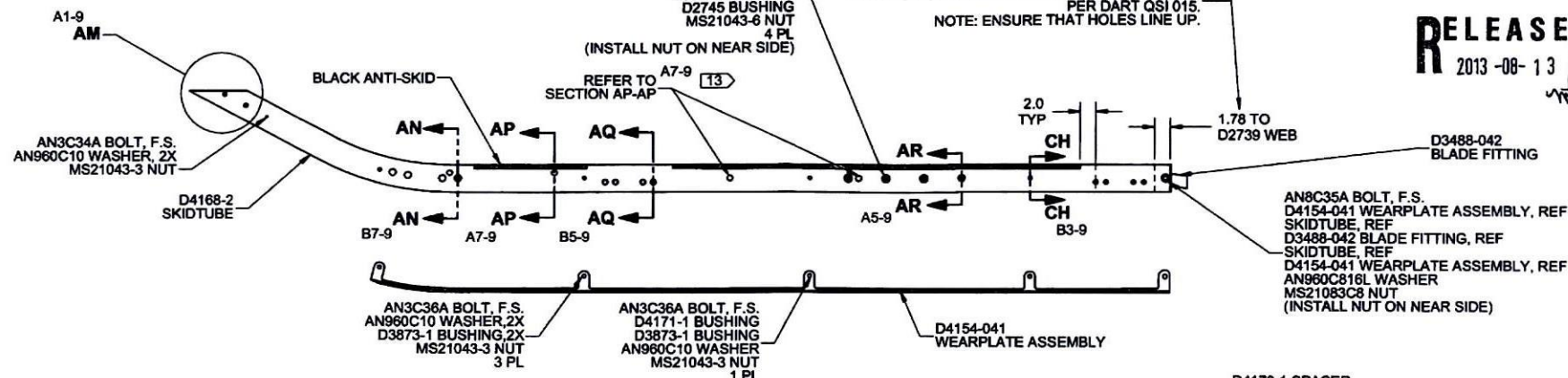




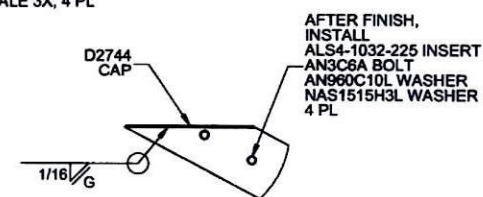
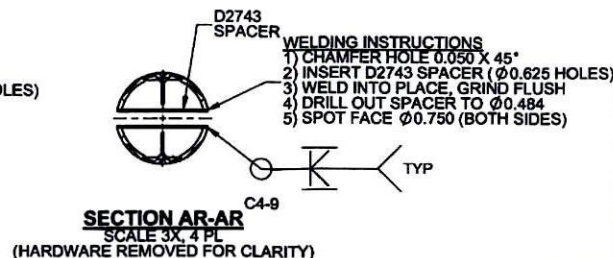
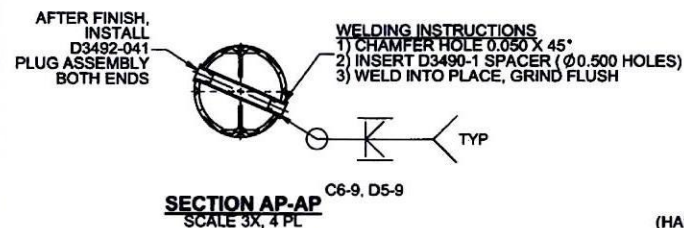
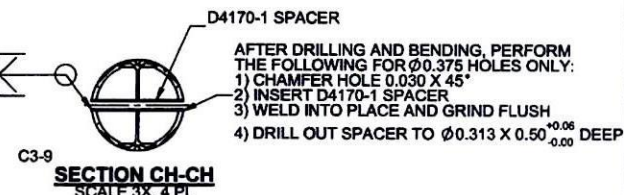
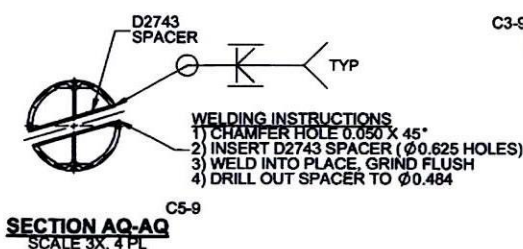
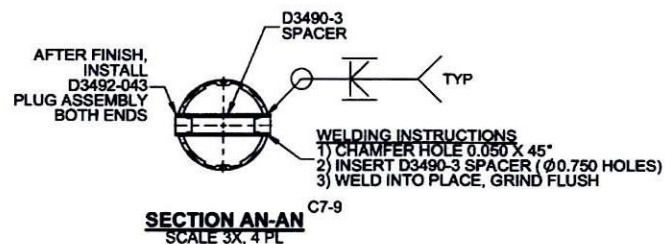
**RELEASED**  
2013-08-13

AN6C44A BOLT, F.S.  
D2745 BUSHING  
D3631-1 WASHER  
SKIDTUBE, REF  
D3631-1 WASHER  
D2745 BUSHING  
MS21043-6 NUT  
4 PL  
(INSTALL NUT ON NEAR SIDE)

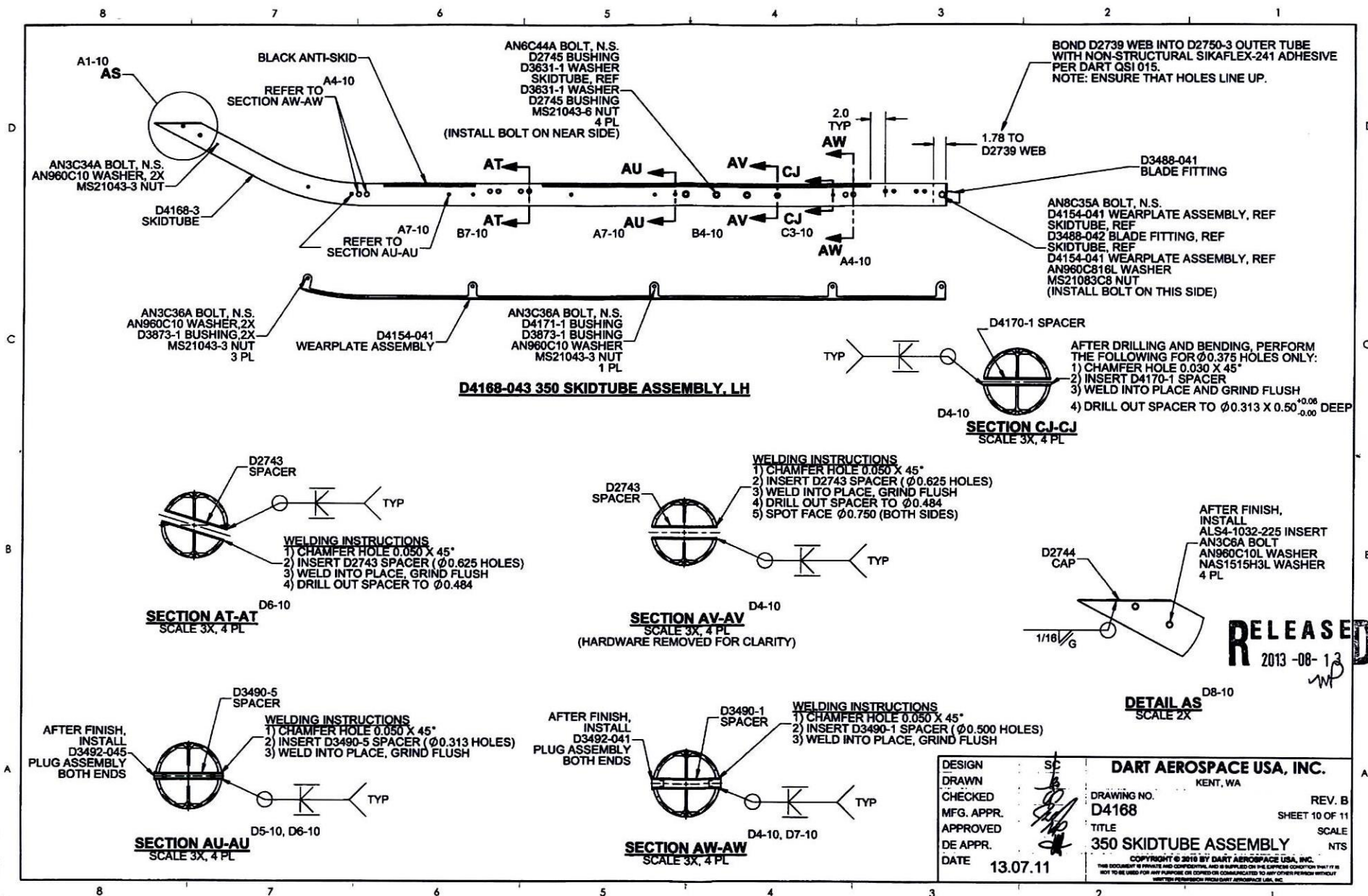
BOND D2739 WEB INTO D2750-2 OUTER TUBE  
WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE  
PER DART QSI 015.  
NOTE: ENSURE THAT HOLES LINE UP.



**D4168-042 350 SKIDTUBE ASSEMBLY, RH**

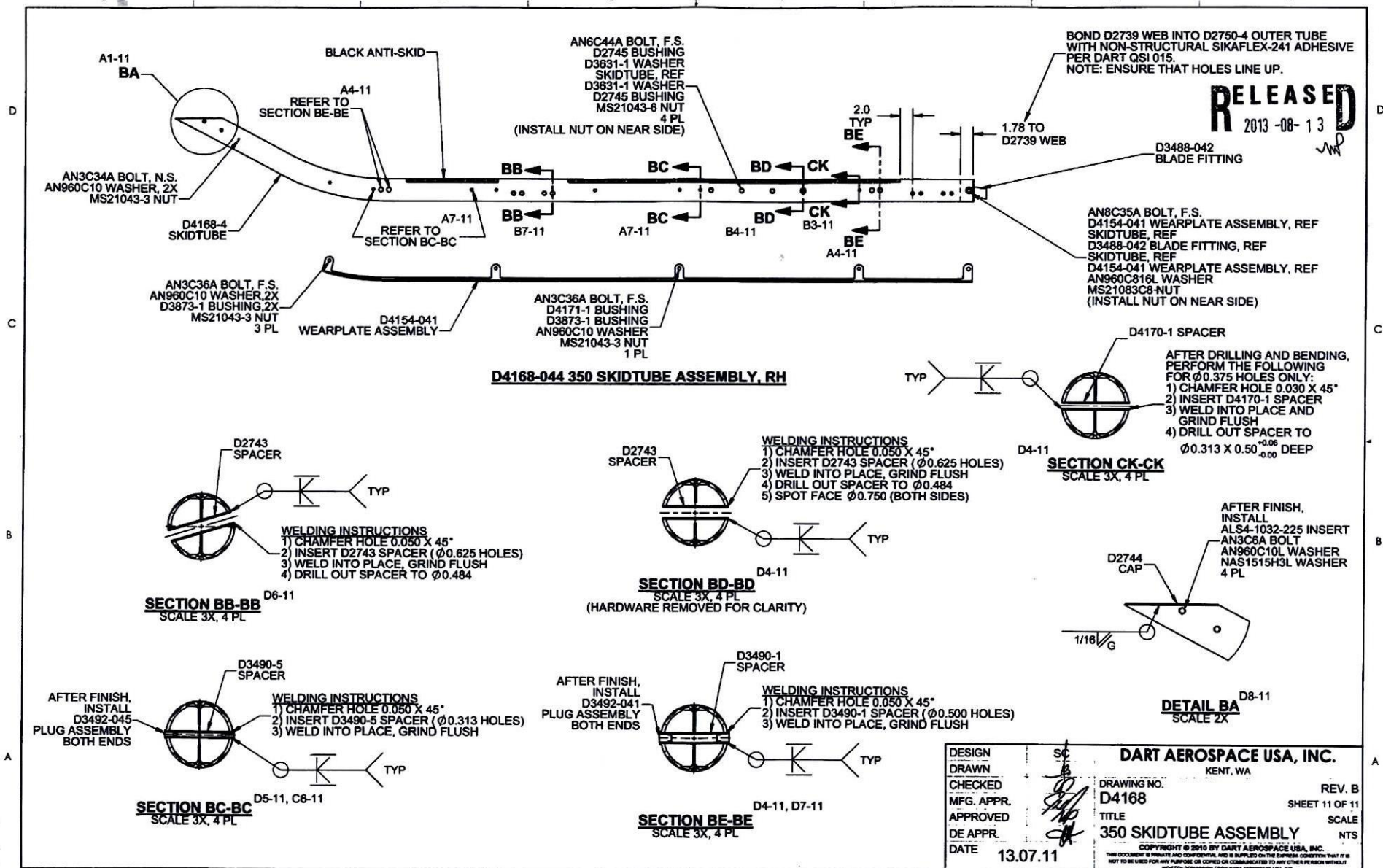


|            |                                                                                       |                                                                                                                                                                                                                                                                                                     |               |
|------------|---------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------|
| DESIGN     |  | <b>DART AEROSPACE USA, INC.</b>                                                                                                                                                                                                                                                                     |               |
| DRAWN      |                                                                                       | KENT, WA                                                                                                                                                                                                                                                                                            |               |
| CHECKED    |                                                                                       | DRAWING NO.                                                                                                                                                                                                                                                                                         | REV. B        |
| MFG. APPR. |                                                                                       | D4168                                                                                                                                                                                                                                                                                               | SHEET 9 OF 11 |
| APPROVED   |                                                                                       | TITLE                                                                                                                                                                                                                                                                                               | SCALE         |
| DE APPR.   |                                                                                       | <b>350 SKIDTUBE ASSEMBLY</b>                                                                                                                                                                                                                                                                        |               |
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8 7 6 5 4 3 2 1



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2013-08-13

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|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|----|--|-----------------------------|--|
| DESIGN                                                                                                                                                                                                                                                                                                                                                                    |  | SC |  | DART AEROSPACE USA, INC.    |  |
| DRAWN                                                                                                                                                                                                                                                                                                                                                                     |  | SC |  | KENT, WA                    |  |
| CHECKED                                                                                                                                                                                                                                                                                                                                                                   |  | SC |  | DRAWING NO. D4168           |  |
| MFG. APPR.                                                                                                                                                                                                                                                                                                                                                                |  | SC |  | REV. B                      |  |
| APPROVED                                                                                                                                                                                                                                                                                                                                                                  |  | SC |  | SHEET 11 OF 11              |  |
| DE APPR.                                                                                                                                                                                                                                                                                                                                                                  |  | SC |  | SCALE NTS                   |  |
| DATE 13.07.11                                                                                                                                                                                                                                                                                                                                                             |  | SC |  | TITLE 350 SKIDTUBE ASSEMBLY |  |
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Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

## Master Unit 000471

| Containers on Master Unit 000471 |               |                  |           |          |
|----------------------------------|---------------|------------------|-----------|----------|
| Serial No                        | Part No       | Customer Part No | Status    | Quantity |
| S038743                          | AN3C37A       |                  | Allocated | 1        |
| S038742                          | AN3C42A       |                  | Allocated | 1        |
| S038741                          | AN8C21A       | AN8C21A          | Allocated | 2        |
| S038740                          | D2741         | D2741            | Allocated | 1        |
| S038739                          | D3493-1       |                  | Allocated | 2        |
| S038738                          | MS21083C8     | MS21083C8        | Allocated | 2        |
| S038737                          | NAS1149D0863J | NAS1149D0863J    | Allocated | 2        |